



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

Rush

D350-636-016
Job Sheet 167339-B



Part No: D350-636-016

Job Qty: 1 ea

Part Name: Skidtube RH, Run-on Landing Wearplates, DART(Apical) Cylind./Aerazur Float Comp.



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/27/17

Job Tracking No:

Due Date: 11/24/17

Created By: Mario Poulin

Type: Stock

Description:

Customer: Air Methods Corporation (CAMET01)

7301 South Peoria Street Englewood, CO, 80112 USA ph:(303) 792-7400

Ship Via:

PMA

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		11/23/17	0.00	0.00	Start Up Skidtubes		
110	Skidtubes	1 pcs		11/23/17	0.00	4.78	Skidtubes		<i>MBG BE</i>
120	QC	1 pcs		11/23/17	0.00	0.00	QC10		<i>PD 18-01-11</i>
130	QC	1 pcs		11/23/17	0.00	0.00	QC5		<i>AP 18-1-11</i>
140	HandFinish	1 pcs		11/23/17	0.00	0.98	HandFinish1		<i>AP 18-1-12</i>
150	QC	1 pcs		11/23/17	0.00	0.00	QC7		<i>BE 18-01-15</i>
160	Skidtubes	1 pcs		11/23/17	0.00	4.78	Skidtubes		<i>5.4.18-4-15 BE</i>
170	QC	1 pcs		11/23/17	0.00	0.00	QC10		<i>38 DAE</i>
180	QC	1 pcs		11/23/17	0.00	0.00	QC5		<i>9-50 38</i>
190	HandFinish	1 pcs		11/23/17	0.00	0.98	HandFinish2		<i>2018/01/19 JSL</i>
200	SprayPaint	1 pcs		11/23/17	0.00	0.61	Spray Paint		<i>DT 18-01-21</i>
210	QC	1 pcs		11/23/17	0.00	0.00	QC14		<i>W 18-1-22</i>
230	HandFinish	1 pcs		11/24/17	0.00	0.98	HandFinish4		<i>DAE 18-1-24</i>
240	QC	1 pcs		11/24/17	0.00	0.00	QC5		<i>38</i>
250	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging1		<i>JAN 24 2019</i>
260	QC	1 pcs		11/24/17	0.00	0.00	QC4		<i>Smr</i>
265	DC	1 pcs		11/24/17	0.00	0.00	DC		<i>Smr</i>
270	Packaging	1 pcs		11/24/17	0.00	0.00	Packaging3		<i>Smr</i>
280	QC21-FG	1 Ea		11/24/17	0.00	0.00	QC21		<i>JAN 24 2019</i>

Part Op 110 - 1- Pick D2600-3 Bent 4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting, section R
Descriptions: and open to 0.500" 6- Drill most FWD wearplate hole using DT9678 locating of 66.54" hole 7- Open up holes of Detail J to 0.297" (total of 2 holes per side) + .201" (total of one hole per side) as per dwg D4168.

160 - 1-Open up holes using hole saw of Detail L and ground handling to 0.625" (total of 8 holes per side) 2-Open up holes using hole saw of Detail K to 0.750" (total of 4 holes per side) 3- Open float hole to 0.500" using uni-bit (4 per side) and Run on wearplate holes to .375" 4 per side 4-Chamfer holes of Detail K,L, ground handling and float holes per dwg D4168 (welding instructions on sheet 9) 8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004 11- Spot face ground handling holes section (total of 4 places per side) as per dwg D4168 12- C'bore section CH-CH. ADJUST TOOLING AS REQUIRED. 13- Deburr holes, ensure tube is free of all scratches before sending to paint.

***** FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING HOLE IN TUBE ***** REF TO W/O BATCH: *****

180 - ***VERIFY C'BOARD IS GOOD***

190 - Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200 - 1- PRIME AS PER DWG AND QSI 005 4.2 *Primer: 137670*

210 - Inspect for foreign object per QSI 024

230 - 1- Install inserts as per Dwg D4168

white paint 138714

DART
AEROSPACE
S031431

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Skidtube RH, Run-on Landing Wearplates, DART(Apical)
Cylind./Aerazur Float Comp.

PART NO:

D350-636-016

Revision:

Operation:

Change No:

Start up Operation

CHG005

Mfg Date: 01/11/18

Job No: 167339-B

250 - If making a D350-636-216

260 - *****ensure antiseize is on AN8C21A bolts*****

265 - record fwd angle: 89.8° Photocopy blue file and type labels per PPP D350-636-016 CHG 005

270 - Identify and pack for shipping as per PPPD350-636-016 Location : FG071

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	D2600-3-BENT-RH <u>5030354</u>	0	0	0	0
	D2744 <u>5003318</u>	1	0	0	0
160-Skidtubes	D2739 <u>165489</u>	1	15	0	0
	D2743 <u>3160400</u>	8	145	0	0
	D3490-1 <u>F160394x3</u>	4	33	0	0
	D3490-3 <u>F165397x1</u>	4	20	0	0
230-HandFinish	ALS4-1032-225 <u>F1135498-24</u>	1	897	0	0
	AN3C34A <u>5000940</u>	1	19	0	0
	AN3C36A <u>F1132381</u>	4	586	0	0
	* AN3C37A <u>5035015</u>	1	68	0	0
	* AN3C42A <u>5035016</u>	1	60	0	0
	AN3C6A <u>F1137361-1</u>	4	88	0	0
	AN6C44A <u>F1137055-1</u>	4	251	0	0
	AN8C35A <u>F1137203</u>	1	99	0	0
	D2745 <u>5000390</u>	8	92	0	0
	D3488-042 <u>F165333</u>	1	5	0	0
	D3492-1 <u>5025647</u>	8	59	0	0
	D3492-3 <u>F165369</u>	8	101	0	0
	D3631-1 <u>5008168</u>	8	4	0	0
	D3873-1 <u>F164363 (x7)</u>	7	171	0	0
	D4154-041 <u>F163961</u>	1	7	0	0
	D4170-1 <u>6164067</u>	4	22	0	0
	D4171-1 <u>F153784</u>	1	13	0	0
	MS21043-3 <u>F1136182-40</u>	5	829	0	0
	MS21043-6 <u>F1138414-39</u>	2	66	0	0
	MS21083C8 <u>F1138238-1</u>	1	7	0	0
	NAS1149C0332R <u>5027570</u>	4	4,758	0	0
	NAS1149C0363R <u>F1133077-09</u>	9	221	0	0
	NAS1149C0832R <u>F1135536-0</u>	1	118	0	0
	NAS1515H3L	4	222	0	0
	NAS1611-010 <u>F1137361-25</u>	8	123	0	0
	NAS1611-013 <u>5022044</u>	8	117	0	0
250-Packaging	AN8C21A	2	239	0	0
	D2741	1	70	0	0
	D3493-1	2	42	0	0
	MS21083C8	2	7	0	0
	NAS1149D0863J	2	209	0	0

Part Specifications

Specifications could not be found.

Plex 10/27/17 2:56 PM dart.poulin.mario

000044

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3673-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

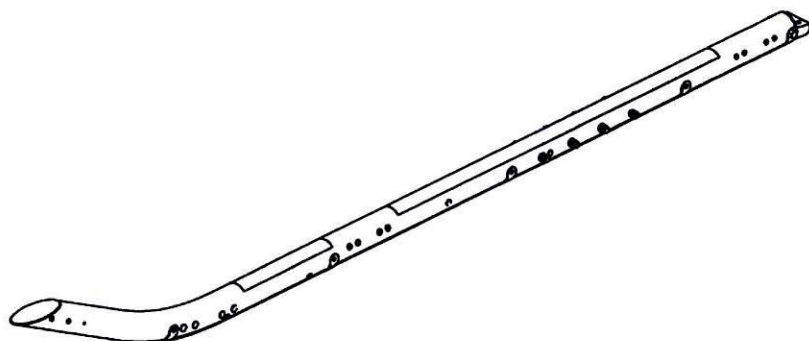
GENERAL NOTES:

- MATERIAL: MAKE D4168-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- WELD PER DART QSI 004
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

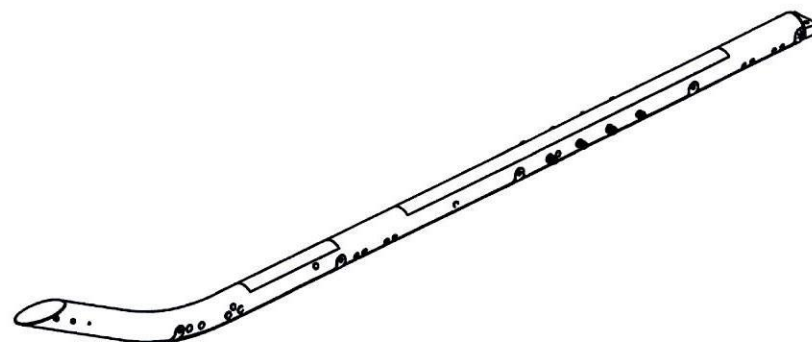
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RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 167389-B
OCT 27 2017

RELEASED
2013-08-13
WMD

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4-5-6-7); UPDATED FINISH OPTIONS. REASON: PAR13-276 AND NCR13-2767	MB	13.07.11
A	NEW ISSUE	SC	10.08.08
REV.	DESCRIPTION	BY	DATE
DESIGN	SE	DART AEROSPACE USA, INC.	
DRAWN	SP	KENT, WA	
CHECKED	SP	DRAWING NO.	REV. B
MFG. APPR.	SP	D4168	SHEET 1 OF 11
APPROVED	SP	TITLE	SCALE
DE APPR.	SP	350 SKIDTUBE ASSEMBLY	NTS
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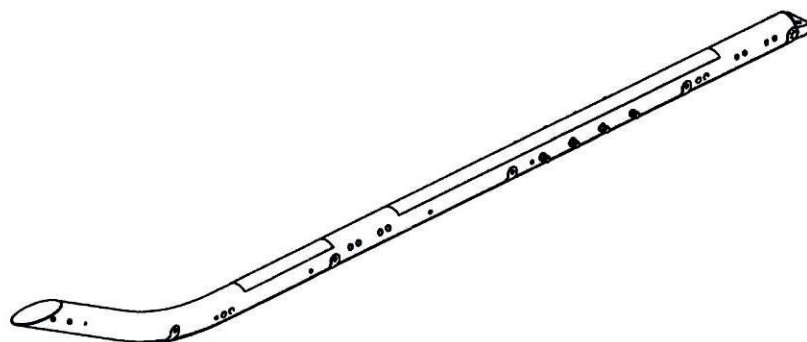
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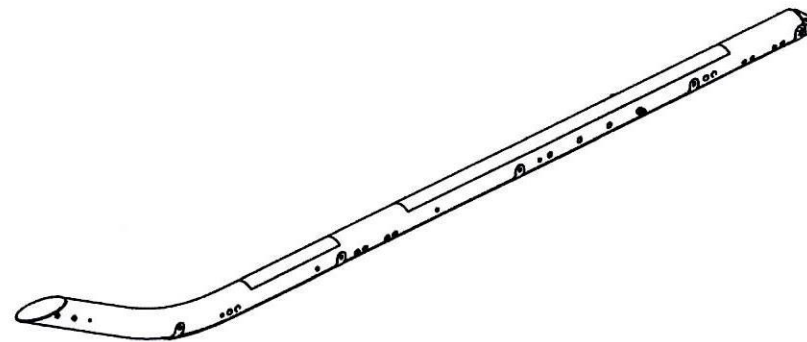
D4168-042 350 SKIDTUBE ASSEMBLY, RH

RELEASE
2013-08-13
MM

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DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO. D4168	REV. B
MFG. APPR.	<i>[Signature]</i>	SHEET 2 OF 11	
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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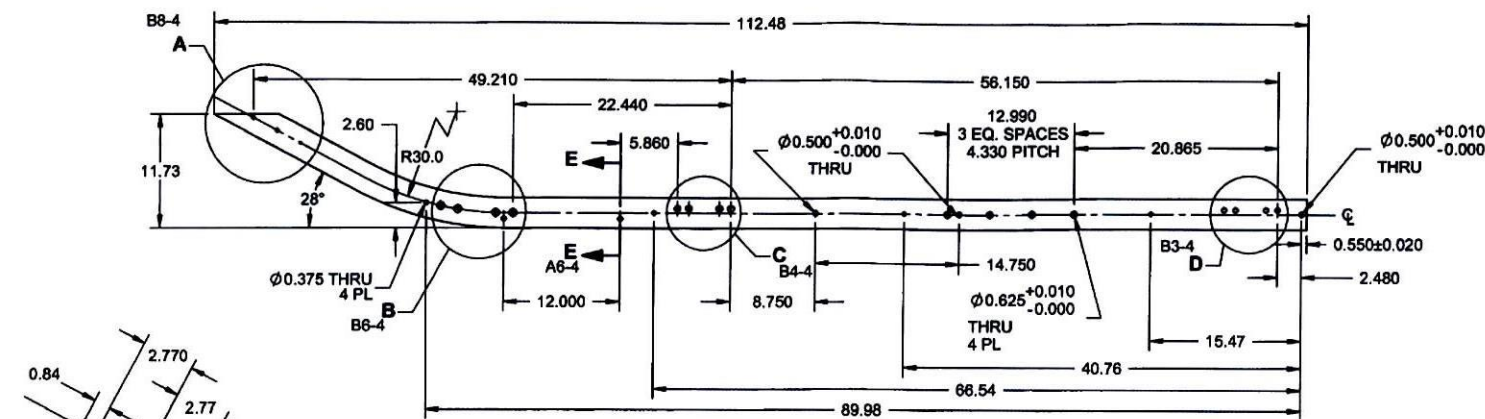
D4168-043 350 SKIDTUBE ASSEMBLY, LH



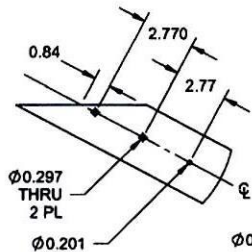
D4168-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
AND

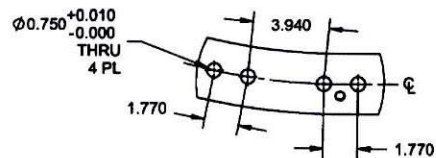
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CHECKED	SC	DRAWING NO.	REV. B
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APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
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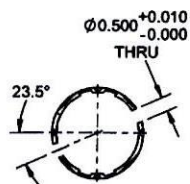
D4168-1 LH SKIDTUBE



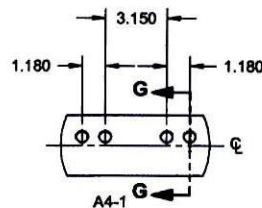
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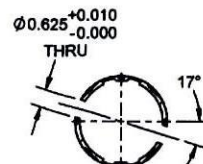
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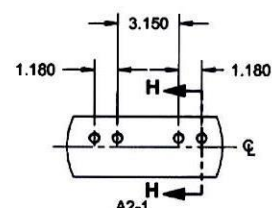
SECTION E-E
SCALE 3X, 2 PL



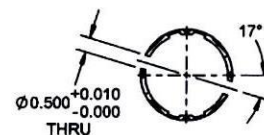
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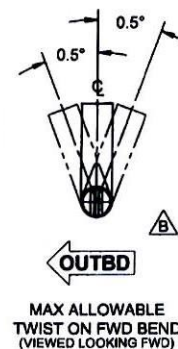
SECTION G-G
SCALE 3X, 4 PL



DETAIL D
SCALE 2X



SECTION H-H
SCALE 3X, 4 PL



MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)

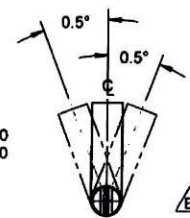
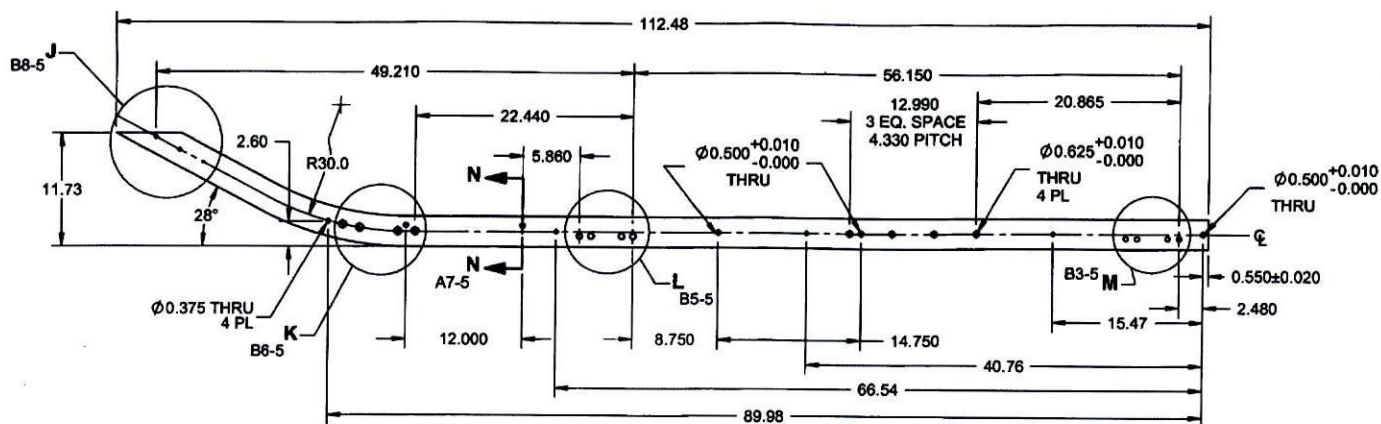
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2013-08-13

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DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.07.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4168
TITLE
350 SKIDTUBE ASSEMBLY
REV. A
SHEET 4 OF 11
SCALE
NTS

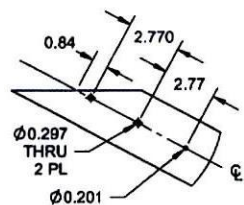
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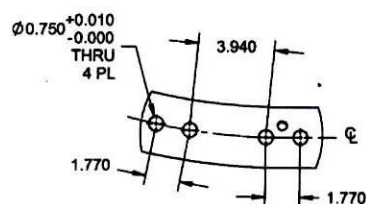
OUTBD

MAX ALLOWABLE
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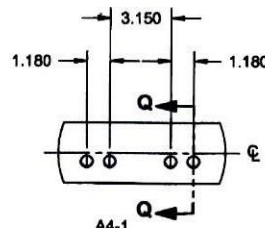
D4168-2 RH SKIDTUBE



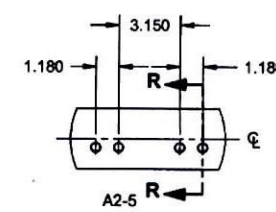
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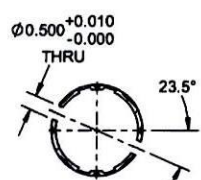
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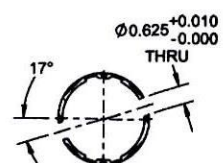
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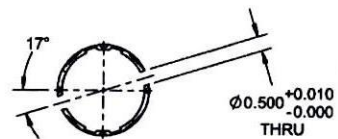
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SECTION N-N
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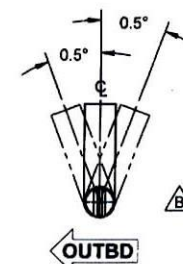
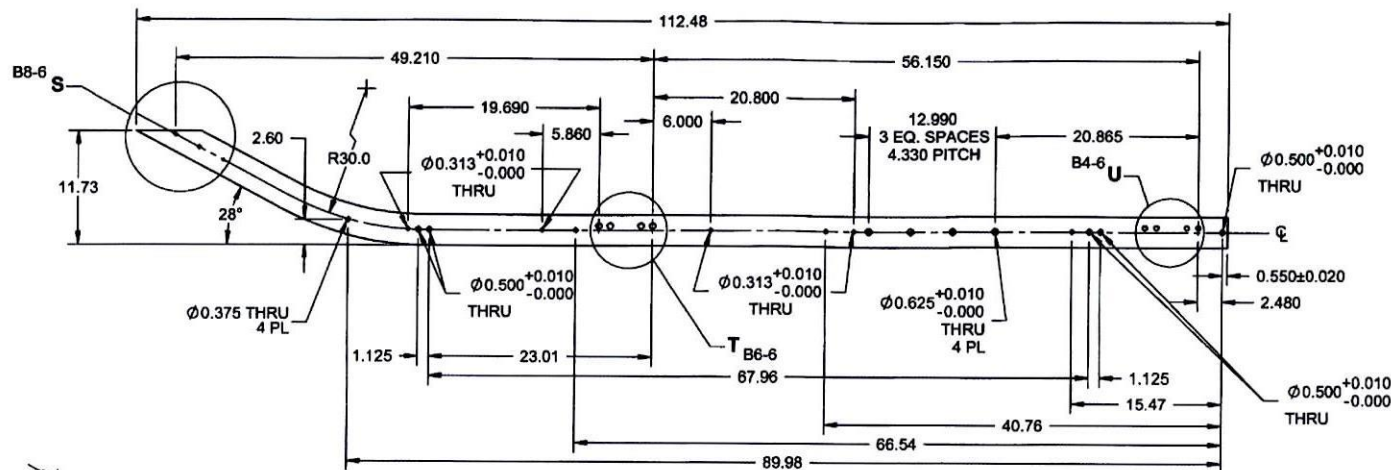
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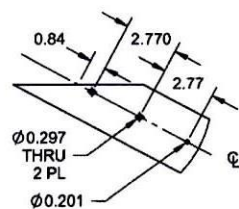
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RELEASED
2013-08-13
JW

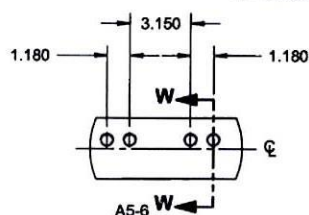
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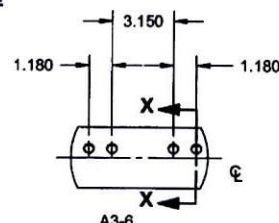
MAX ALLOWABLE
TWIST ON FWD BEND
(VIEWED LOOKING FWD)



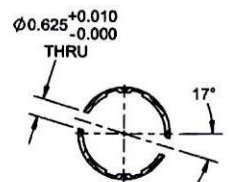
DETAILS
D8-6
SCALE 2X



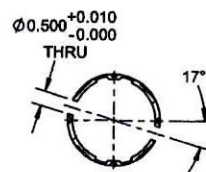
DETAIL T
C5-6
SCALE 2X



DETAIL U
D3-6
SCALE 2X



SECTION W-W
B6-6
SCALE 3X, 4 PL



SECTION X-X
B4-6
SCALE 3X, 4 PL

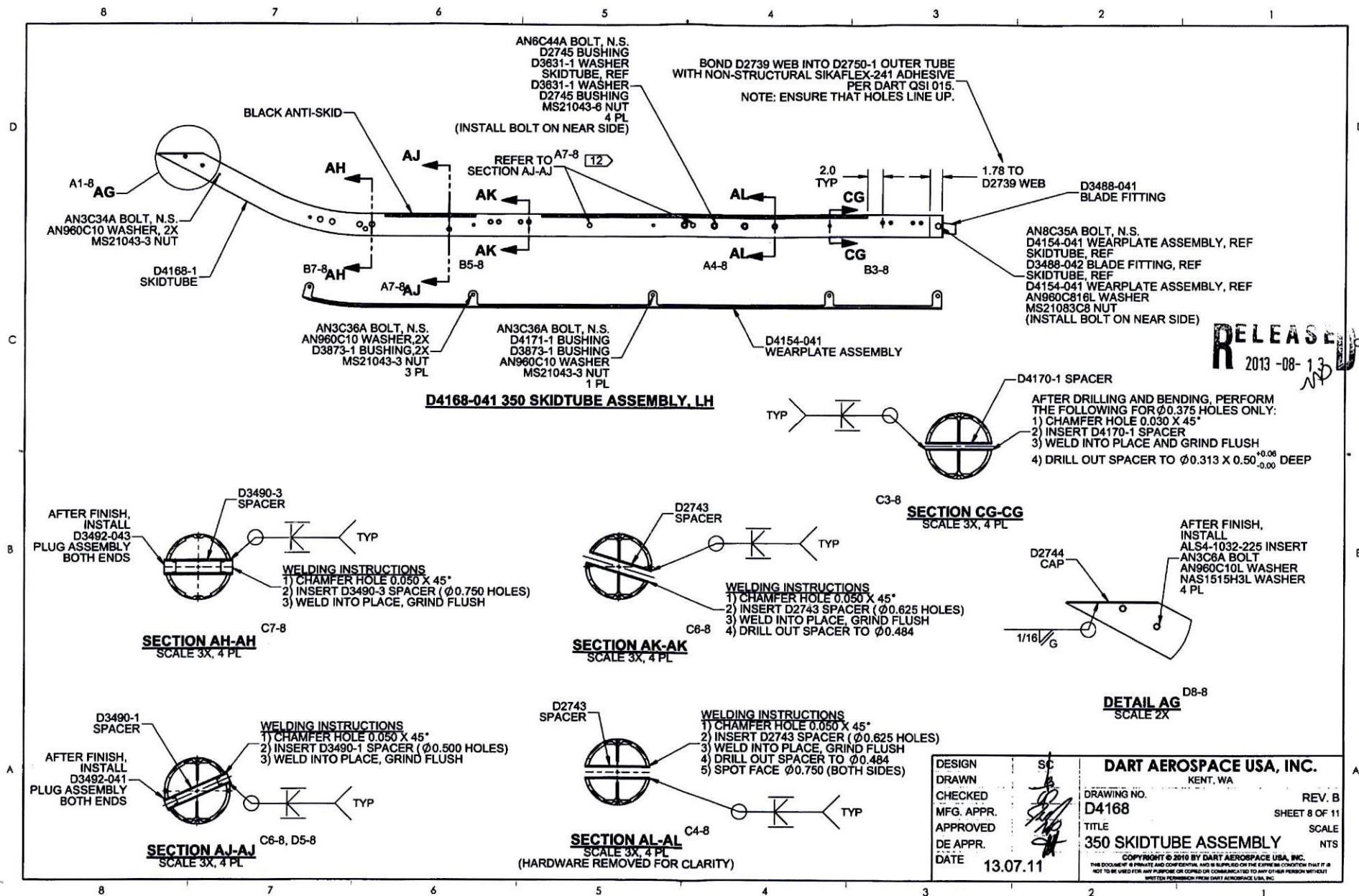
RELEASED
2013-08-13

DESIGN
DRAWN
CHECKED
MFG. APPR.
APPROVED
DE APPR.
DATE 13.07.11

DART AEROSPACE USA, INC.
KENT, WA

DRAWING NO.
D4168
TITLE
350 SKIDTUBE ASSEMBLY
REV. B
SHEET 6 OF 11
SCALE
NTS

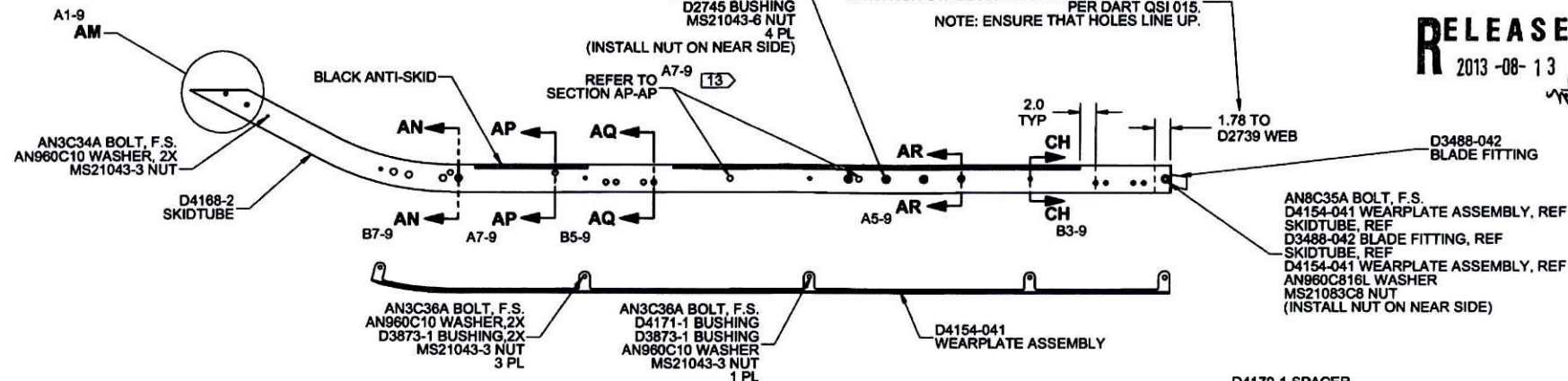
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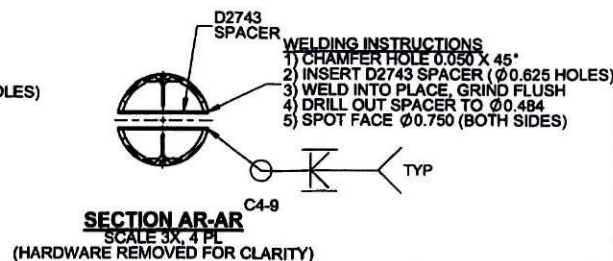
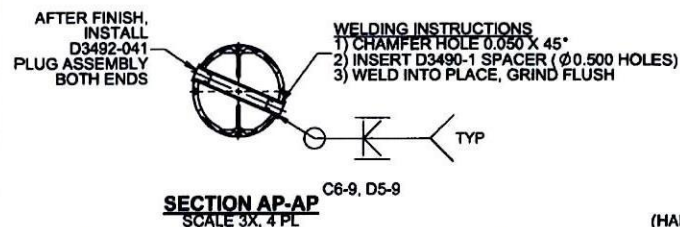
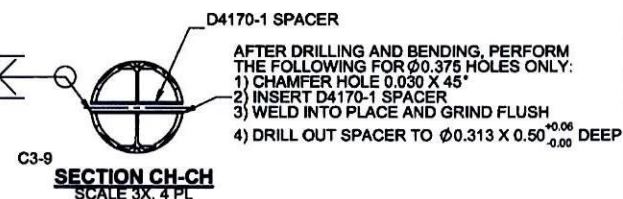
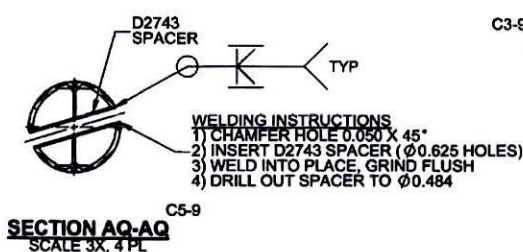
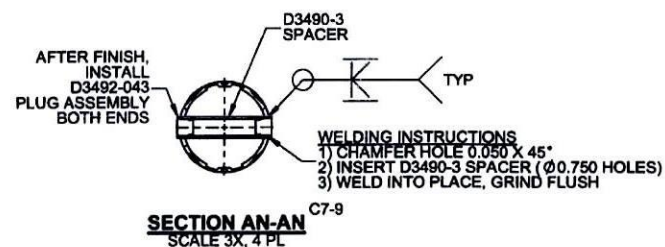
RELEASED
2013-08-13

AN8C44A BOLT, F.S.
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL NUT ON NEAR SIDE)

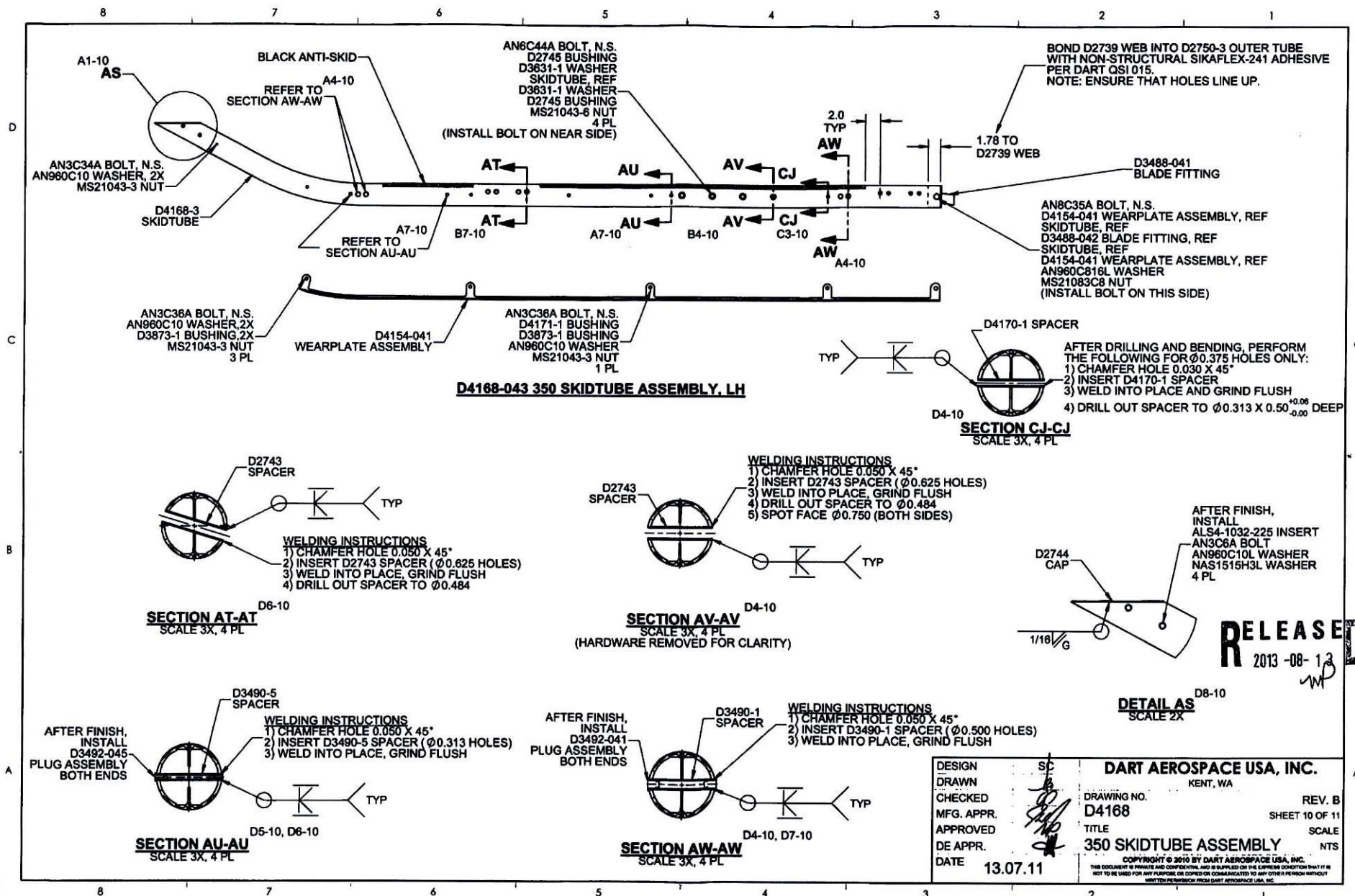
BOND D2739 WEB INTO D2750-2 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015.
NOTE: ENSURE THAT HOLES LINE UP.

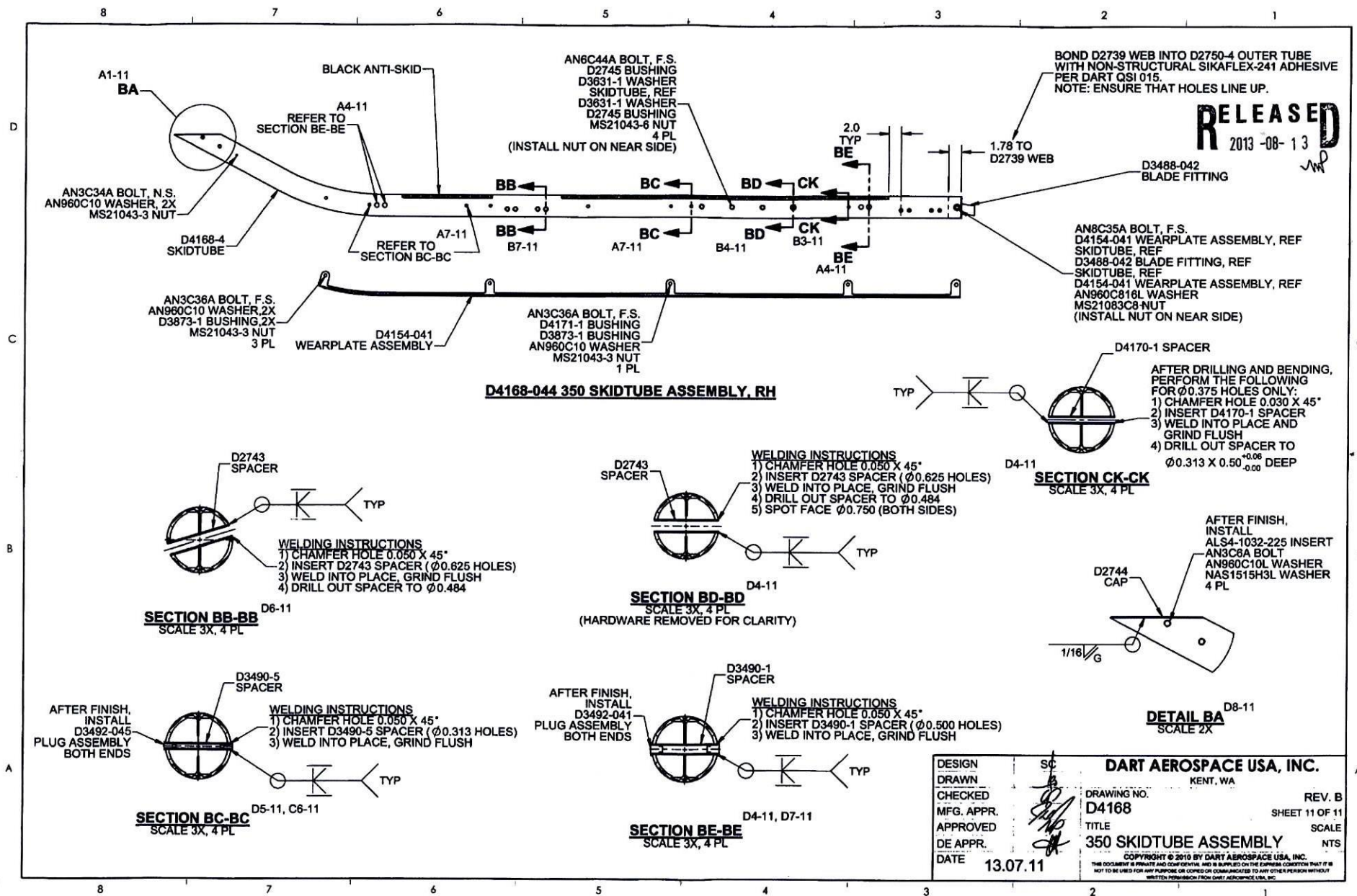


D4168-042 350 SKIDTUBE ASSEMBLY, RH



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CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4168	SHEET 9 OF 11
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 000044

Tel (613) 632-5200

Containers on Master Unit 000044				
Serial No	Part No	Customer Part No	Status	Quantity
S035015	AN3C37A		Allocated	1
S035016	AN3C42A		Allocated	1
S035010	AN8C21A	AN8C21A	Allocated	2
S035008	D2741	D2741	Allocated	1
S035006	D3493-1		Allocated	2
S003494	MS21083C8	MS21083C8	Allocated	2
S035000	NAS1140D09C3J	NAS1140D09C3J	Allocated	2

Change Record

PAGE 1 OF 1

Part Number: D350-636-015/-016

Description: SKIDTUBE STD LH/RH w/ TRAINING WEARPLATE

[illegible]